

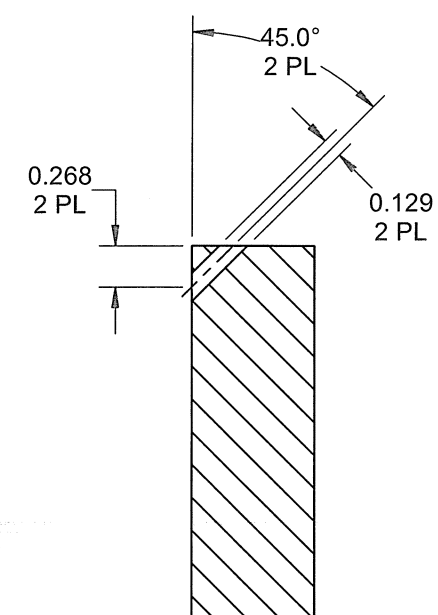
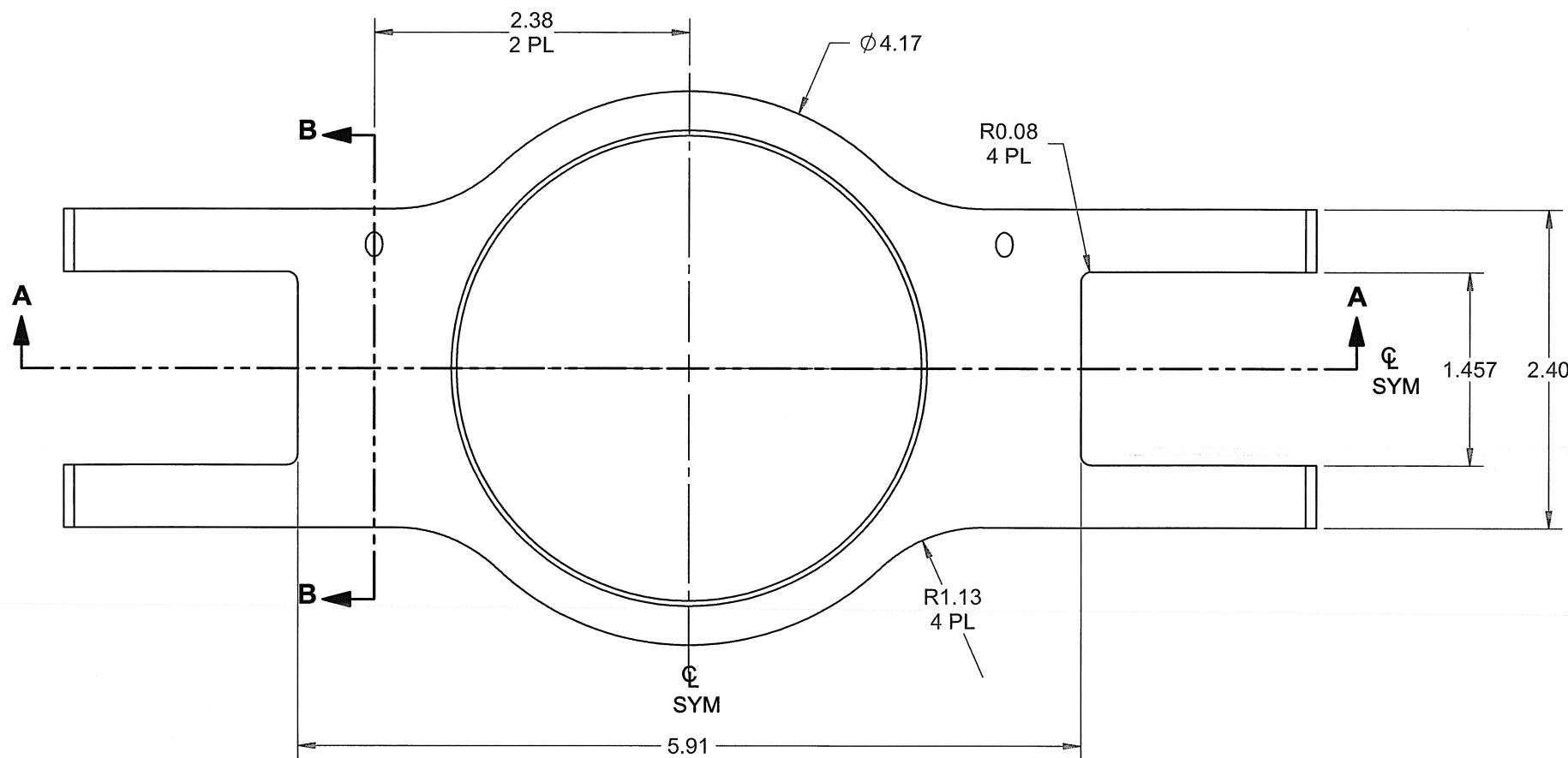
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6400G00131-8G-1	BASE
-2	1	RBW6400G00131-8G-2	SLEEVE
-3	4	RBW6400G00131-8G-3	SCREW
-4	2	RBW6400G00131-8G-4	PIN
-5	4	RBW6400G00131-8G-5	PROTECTION TAPE
6	1	McMaster#98410A350 OR EQUIV	STEEL EXTERNAL RETAINING RING FOR 3-1/2" OD
7	4	McMaster#94895A805 OR EQUIV	STEEL HEX NUT 1/4"-28
8	4	McMaster#90177A215 OR EQUIV	STEEL SPLIT RING 11/16" OD x 1/2" ID. x 1/8" THK
9	2	McMaster#90312A271 OR EQUIV	STEEL WIRE ROPE LANYARD 3/64" DIA. x 6" LG.
10	4	NAS1149F0432P	WASHER

RBW6400G00131-8G UPPER CONICAL RING REMOVAL PULLER T/R

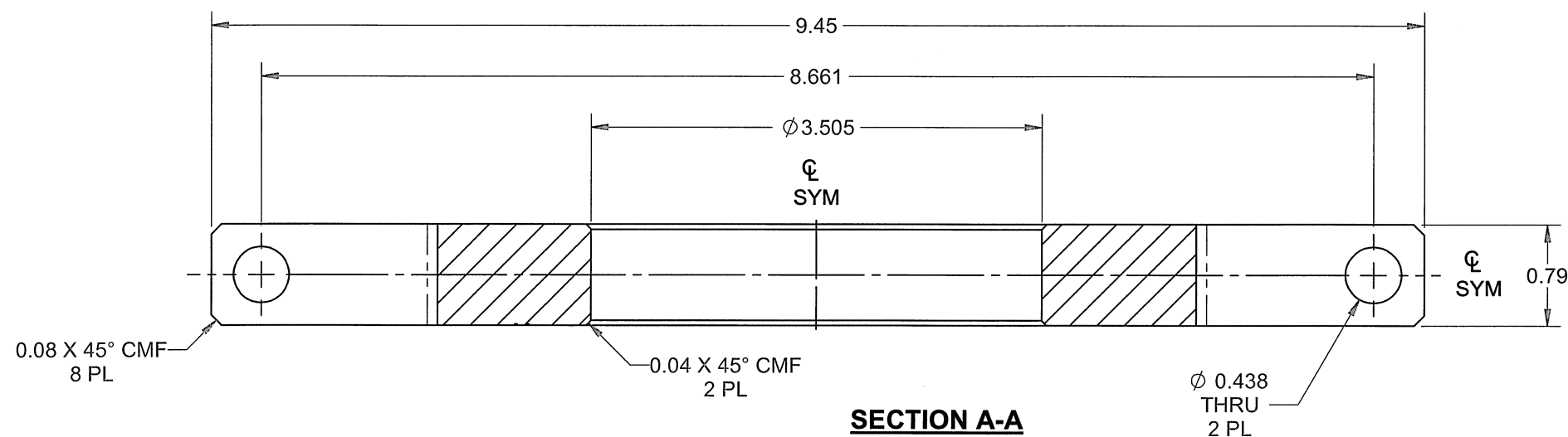
NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN
9) ASSEMBLE ITEMS -5 ADHESIVE BACK ONTO ITEM -1
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

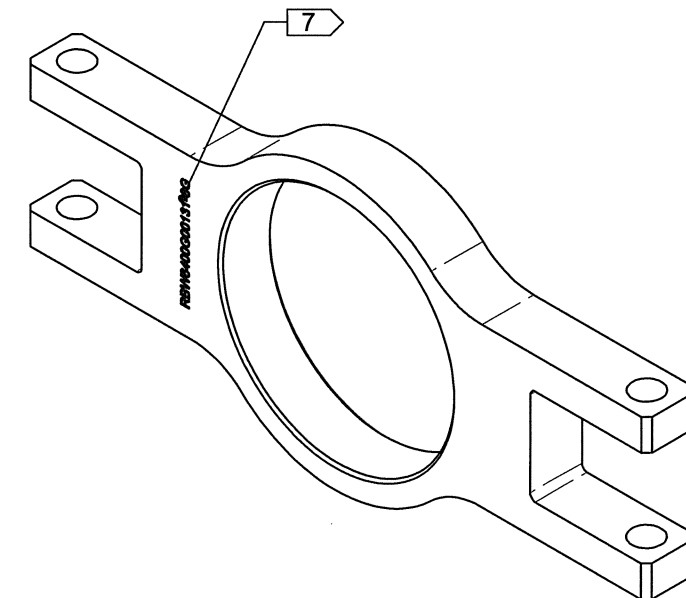
A	NEW ISSUE	19-520	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6400G00131-8G	SHEET 1 OF 6
APPROVED	WSP	TITLE	SCALE
DATE 1/18/2019		UPPER CONICAL RING REMOVAL PULLER T/R	NTS
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SECTION B-B



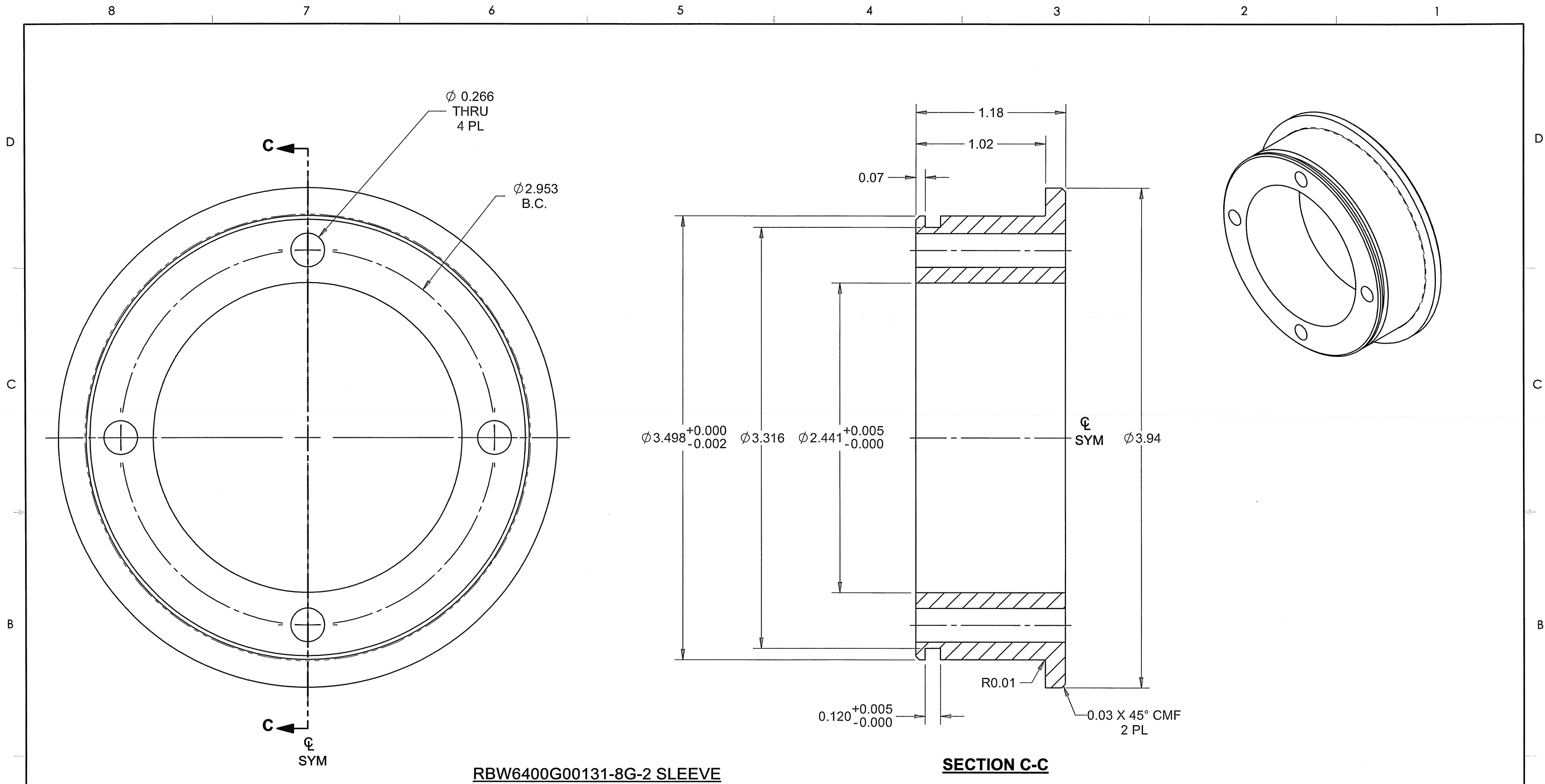
SECTION A-A



- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

RBW6400G00131-8G-1 BASE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6400G00131-8G	SHEET 2 OF 6
APPROVED	VP	TITLE	SCALE
		UPPER CONICAL RING REMOVAL PULLER T/R	NTS
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RBW6400G00131-8G-2 SLEEVE

SECTION C-C

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1^\circ$ / $\pm 1^\circ$
X.XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6400G00131-8G	SHEET 3 OF 6
APPROVED	VP	TITLE	SCALE
DATE 1/18/2019		UPPER CONICAL RING REMOVAL PULLER T/R	NTS
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0.05 CMF

SECTION D-D

30° CMF

0.50

Ø
SYM

0.50

Ø0.59

0.39
4 PL0.21
REF

1/4"-28 UNF

0.02 X 45° CMF

Ø0.190

0.04
REF

2.56

0.32

3.03

RBW6400G00131-8G-3 SCREW**NOTES:**

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6400G00131-8G	SHEET 4 OF 6
APPROVED	<i>VP</i>	TITLE	SCALE
DATE 1/18/2019		UPPER CONICAL RING REMOVAL PULLER T/R	NTS
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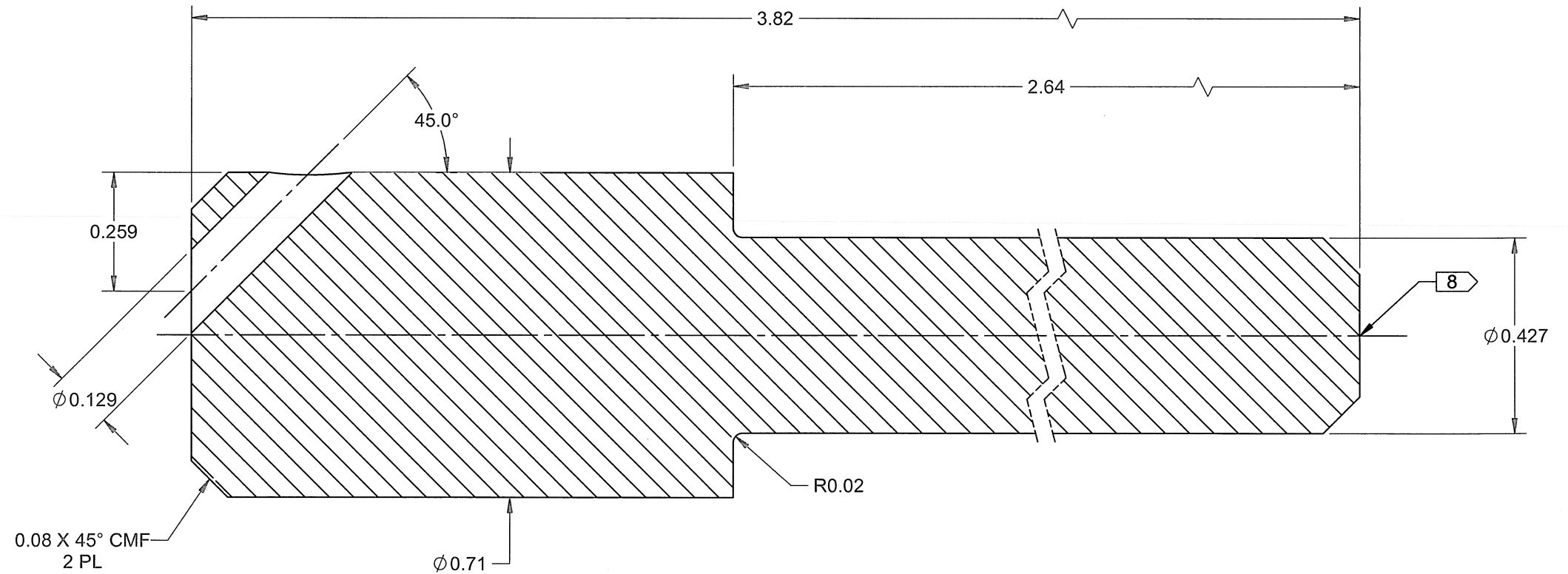
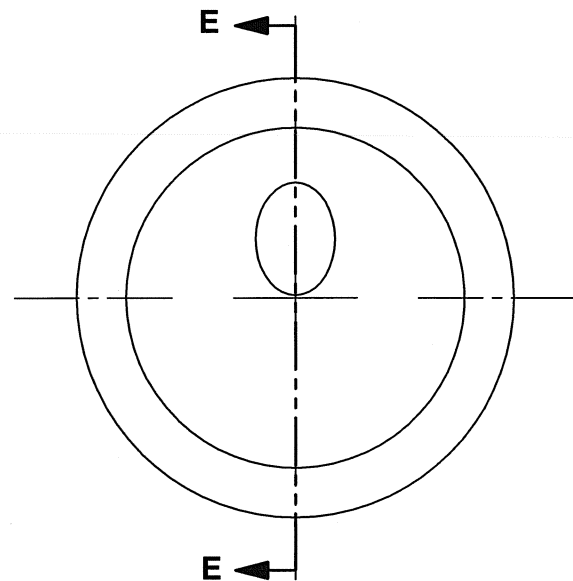
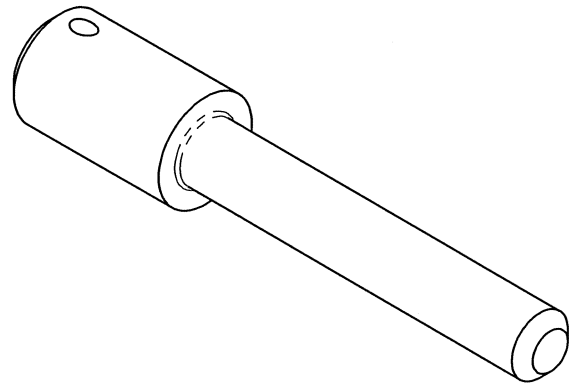
1

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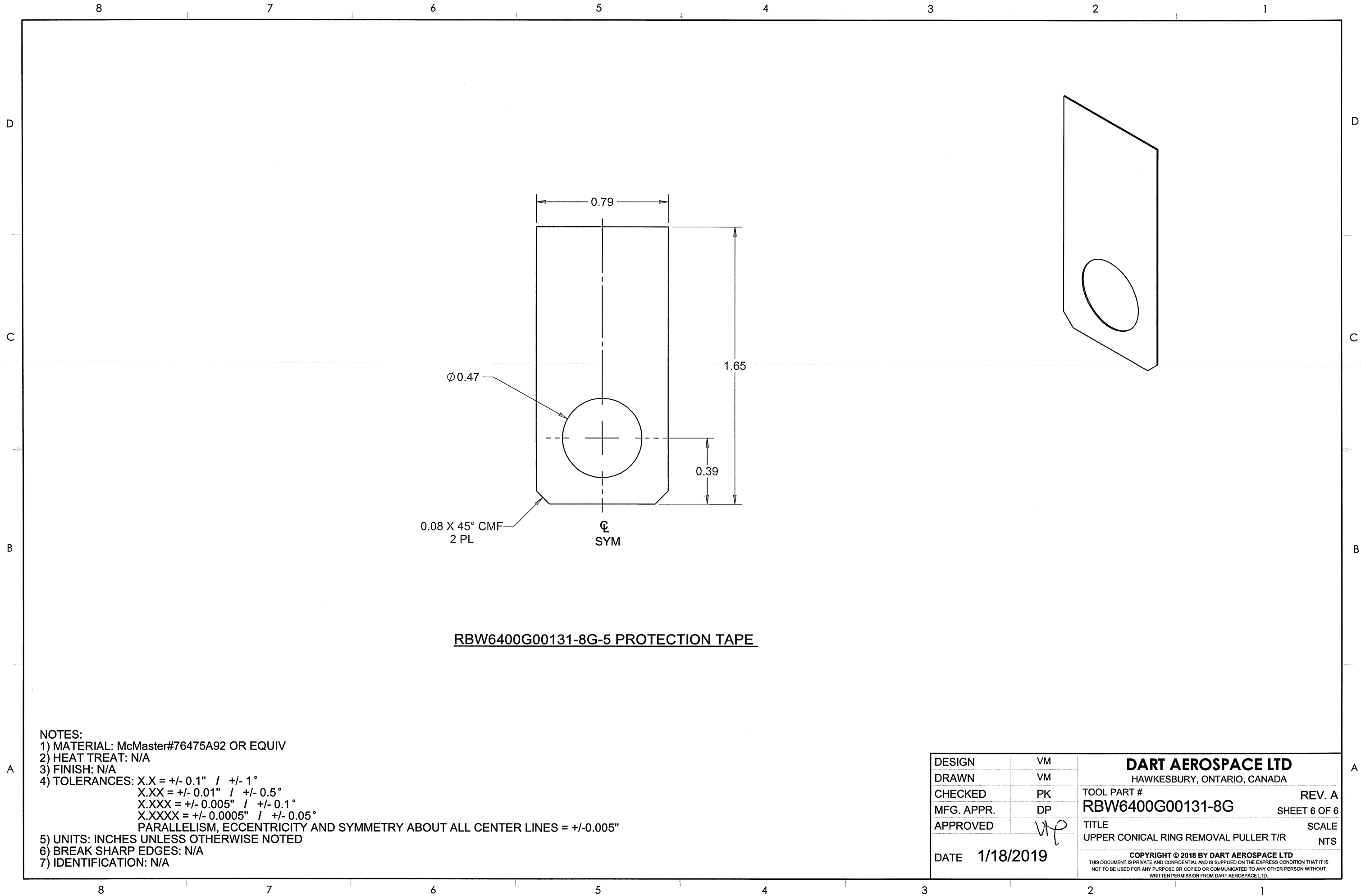
SECTION E-E

RBW6400G00131-8G-4 PIN

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6400G00131-8G	SHEET 5 OF 6
APPROVED	WY	TITLE	SCALE
DATE 1/18/2019		UPPER CONICAL RING REMOVAL PULLER T/R	NTS
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RBW6400G00131-8G-5 PROTECTION TAPE

NOTES:

- 1) MATERIAL: McMaster#76475A92 OR EQUIV
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6400G00131-8G	SHEET 6 OF 6
APPROVED	VP	TITLE	SCALE
DATE 1/18/2019		UPPER CONICAL RING REMOVAL PULLER T/R	NTS
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